



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE350A94-2706-00-05

Job Sheet 170604



Part No: RBE350A94-2706-00-05

Job Qty: 6 ea

Part Name: Pin



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/17/18

Job Tracking No:

Due Date: 2/27/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A94-2706-00 REV 6 IPP REV A 18-01-16 NEW ISSUE JFC VERIFIED DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		2/27/18	0.00	0.00	Start Up Small Fab-2		ML
110	Small Fab	6 pcs		2/27/18	0.00	3.00	Small Fab-3		ML DAS
120	QC	6 pcs		2/27/18	0.00	0.00	QC5		38
121	Outsource	6 pcs		2/27/18	0.00	0.00	Outsource12 P003417		CC 18-03-22 AT 18/03/21
123	Packaging	6 pcs		2/27/18	0.00	0.00	Packaging2		APR 18/03/17 11 MAR 2 2018
125	QC	6 pcs		2/27/18	0.00	0.00	QC6		9-89
127	Small Fab	6 pcs		2/27/18	0.00	1.50	Small Fab-8		
129	QC	6 pcs		2/27/18	0.00	0.00	QC5		
130	Packaging	6 pcs		2/27/18	0.00	0.00	Packaging3-1		
140	QC21-SA	6 Ea		2/27/18	0.00	0.00	QC21		DAS 21 MAR 2 8 2018 9-80

Part Op 90 - see engineering sign off for lanyard

Descriptions: 110 - Assemble as per DWG. Sheet 2 - Loctite 580 B 138828 Exp: 0/19

121 - Issue P/O to Groupe Altech; PO 025418 - Black oxide finish, MIL-C-13924C Class 1 - Certificate of Conformity is required

123 - Receive

127 - Fabricate lanyard 2.75 inch and Assemble as per DWG

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
3896T31 205016493	Ferule 1/16 X 3/8" - Aluminum	12 Ea (2 ea)	90-Start up Operation	
91595A142 51	Dowel Pin Ø3mm x 40mm	6 Ea (1 ea)	90-Start up Operation	
CL-2-C 25	Lanyard Wire	2.4960 ft (.416 ea)	90-Start up Operation	
NAS 1756-12	Remove Before Flight	6 (1 ea)	90-Start up Operation	
RBE350A94-2706-00-05A	Pin Shaft	6 Ea (1 ea)	90-Start up Operation	

Part Specifications

Specifications could not be found.

Plex 1/17/18 11:34 AM Dart.lajeunesse.marie

DML 3-28



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Container No: S053984



Part: RBE350A94-2706-00-05

Job No: 170604

Serial No/Batch: S053984

Revision: 6

Inspector:

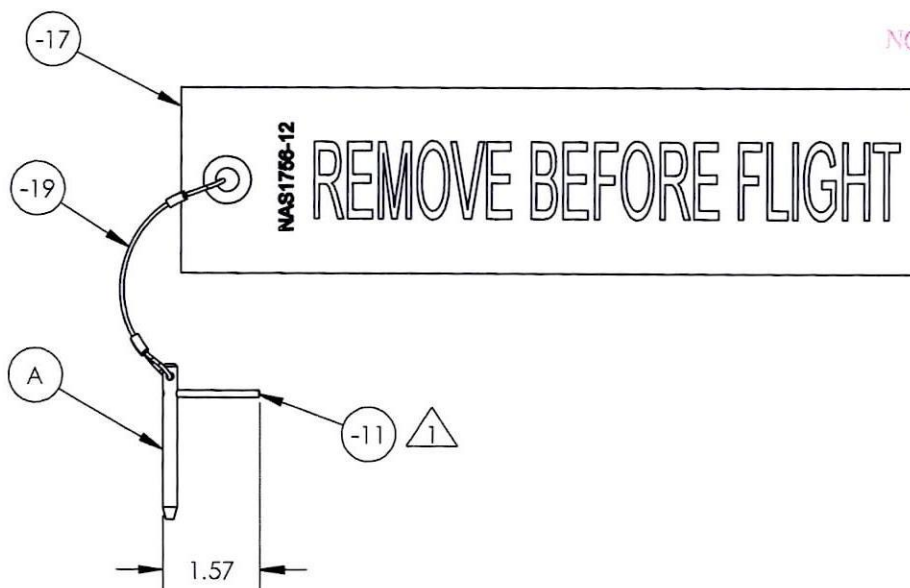
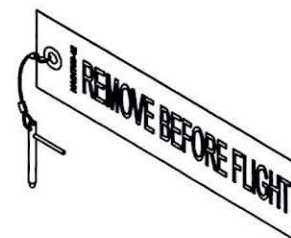
Date: 03/22/18

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REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				
6	16-0281	-01, -03, -05, -07, -09 ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D. ADDED -17, -19, NOTE 1		1/12/2017	RJC	JAG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 170604 NCS
18-01-18



ASSY P/N	A P/N
-01	-01A
-03	-03A
-05	-05A
-07	-07A
-09	-09A

NOTE:

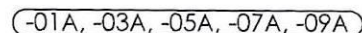
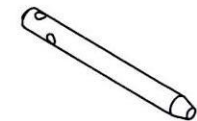
1 USE LOCTITE 680 TO ASSEMBLE.

DART AEROSPACE	
TITLE RIGGING PIN SET	
DWG NO. RBE350A94-2706-00-01	REV 6
MAT'L HEAT TREAT FINISH BLACK OXIDE SPEC QMSI-6.2.2, B.O. REV D	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125✓
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	EUROCOPTER AS350/355
SCALE 1:3	DATE 9/11/2009
SHEET 2 OF 3	

-01, -03, -05, -07, -09

PIN

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
3		MOVED LENGTH B DIMENSION TO Ø.118in. HOLE CENTERLINE & ADDED 1.5mm TO -Ø1 THRU -Ø9 PINS IN TABLE. ADDED A TOLERANCE TO Ø.118in HOLE TO ACHIEVE A LIGHT PRESS FIT FOR -11. CH'D HOLE FROM Ø.118 TO Ø.113 FOR CABLE TIES @ END OF PIN PER S.E.	5/26/2015	RJC	RW
4	15-0120	CH'D TOLERANCE BLOCK WAS .XXX ± .004 IN .XXX ± .005.	5/26/2015	DPD	JAG
6	16-0281	-01A -03A -05A -07A -09A CH'D DIM WAS 2X Ø.118 +.001/- .000 THRU ALL IS Ø.1180/.1176 THRU ALL (P.F. -11). ADDED DIM Ø.12 THRU ALL. ADDED ENGRAVE DASH No., ADDED ENGRAVE DASH No. COLUMN TO TABLE.	1/12/2017	RJC	JAG



PIN SHAFT

ENGRAVE	PIN DIMENSION TABLE		
DASH No.	P/N	ØA	LENGTH B
-01	-01A	6mm	2.028
-03	-03A	8mm	5.177
-05	-05A	8mm	3.012
-07	-07A	6mm	4.783
-09	-09A	8mm	1.240

			
TITLE			
RIGGING PIN SET			
DWG NO. RB350A94-2706-00-01A			REV 6
MATERIAL O-1		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH SEE -.01, -.03, -.05, -.07, -.09		.XXX ± .005 FRACTIONS ± 1/8	
SPEC		.XX ± .01 ANGLES ± 5°	
		.X ± .1 SURFACES = 125/√	
DRAWN BY:	PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
CHECKED:	DUERFELDT	2. DIMENSIONAL LIMITS APPLY	
OPPS APPR:	ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
QA APPR:	LINDSAY	USED ON MODEL	
APPROVED:	GILBERT	EUROCOPTER AS350/355	
SCALE 1:1	DATE 9/11/2009	SHEET 3 OF 3	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER :			



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039417**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO039417
PO Date: 3/23/18
Due Date: 4/3/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, Chrisoula

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	171481	RBE703A94-1130-01-25	Tab Adjuster Handle -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 Water Seal - Certificate of Conformity is required	Firmed	4/3/18	6 pcs	0 pcs	6 pcs	\$6.00/pcs	\$36.00
2	171483	RBE703A94-1130-01-29	Tab Adjuster Clamp : URF 17-623 -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 - Certificate of Conformity is required	Firmed	4/3/18	6 pcs	0 pcs	6 pcs	\$6.00/pcs	\$36.00
3	171604	RBW6405G06131-3G-1	Reaction Weldment -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed	4/3/18	2 pcs	0 pcs	2 pcs	\$6.00/pcs	\$12.00
4	170608	RBE350A94-2706-00-09	Pin -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	4/3/18	6 pcs	0 pcs	6 pcs	\$1.55844156/pcs	\$9.35

3/26/2018

PURCHASE ORDER

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	170604	RBE350A94-2706-00-05	Pin -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	4/3/18	6 pcs	0 pcs	6 pcs	\$1.55844156/pcs	\$9.35
6	170606	RBE350A94-2706-00-07	Pin -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	4/3/18	6 pcs	0 pcs	6 pcs	\$1.55844156/pcs	\$9.35
7	170602	RBE350A94-2706-00-03	Pin -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	4/3/18	12 pcs	0 pcs	12 pcs	\$1.55844156/pcs	\$18.70
8	170600	RBE350A94-2706-00-01	Pin -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	4/3/18	24 pcs	0 pcs	24 pcs	\$1.55844156/pcs	\$37.40
9	171469	RBE703A94-1130-01-11	Angle Indicator -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEALANT - Certificate of Conformity is required	Firmed	4/3/18	6 pcs	0 pcs	6 pcs	\$6.00/pcs	\$36.00
10	171485	RBE703A94-1130-01-33	Adjuster -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1: MIL-C-16173 Grade 4 -Certificate of Conformity is required	Firmed	4/3/18	14 pcs	0 pcs	14 pcs	\$1.55844156/pcs	\$21.82
11	174804	RBE350A94-3700-C-03	Bolt -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	4/3/18	3 pcs	0 pcs	3 pcs	\$1.55844156/pcs	\$4.68
12	171734	RBT18520-7	Pivot Bar Weldment -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	4/3/18	6 pcs	0 pcs	6 pcs	\$1.55844156/pcs	\$9.35

DAS
11
9-89

6x

18/03/27

3x

18/03/27 mdf



2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

Certificat de Conformité / Certificate of Compliance

(007845-1)

Bon de Livraison / Packing Slip

007845-1

Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
27-Mar-2018		Aman		039417				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
4	RBE350A94-2706-00-09 Rev.	RBE350A94-2706-00-09 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	6	6	0	0	0
5	RBE350A94-2706-00-05 Rev.	RBE350A94-2706-00-05 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	6	6	0	0	0
6	RBE350A94-2706-00-07 Rev.	RBE350A94-2706-00-07 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	6	6	0	0	0
7	RBE350A94-2706-00-03 Rev.	RBE350A94-2706-00-03 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	BLACK-OXIDE CH	12	12	0	0	0
8	RBE350A94-2706-00-01 Rev.	RBE350A94-2706-00-01 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	24	24	0	0	0
10	RBE703A94-1130-01-33 Rev.	RBE703A94-1130-01-33 BLACK OXIDE COATING: MIL-C-13924 CLASS 1: MIL-C-16173, GRADE 4	BLACK-OXIDE CH	14	14	0	0	0
11	RBE350A94-3700-C-03 Rev.	RBE350A94-3700-C-03 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	3	3	0	0	0
12	RBT18520-7 Rev.	RBT18520-7 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	6	6	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Noûs certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.
We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.